



OK Tigrod 316L

GTAW

Bare, corrosion-resistant, chromium-nickel-molybdenum rods for welding austenitic stainless alloys of the 18% Cr-8% Ni and 18% Cr-10% Ni-3% Mo types. OK Tigrod 316L has good general corrosion resistance, particularly to corrosion in acid and chlorinated environments. The alloy has a low carbon content, which makes it particularly recommended when there is a risk of intergranular corrosion. The alloy is widely used in the chemical and food-processing industries, as well as in shipbuilding and various types of architectural structure.

Welding Current

DC (-)

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Per Pack (kg)	Pallet Weight (kg)
163010R150	1.0	5	840
163012R150	1.2	5	840
163016R150	1.6	5	840
163020R150	2.0	5	840
163024R150	2.4	5	840
163032R150	3.2	5	840
163040R150	4.0	5	840

CLASSIFICATIONS	APPROVALS	TYPICAL ALL WELD METAL COMPOSITION (%)	TYPICAL MECH. PROPERTIES ALL WELD METAL
<u>SFA/AWS A5.9</u>	DNV 316L (-60°C)	C 0.01	<u>Yield Stress, Mpa</u>
ER316L	VdTüV 04270	Si 0.4	470
<u>EN 12072</u>		Mn 1.8	<u>Tensile Strength, Mpa</u>
W 19 12 3 L		Cr 19	650
<u>Werstoffnummer</u>		Ni 12	<u>Elongation, %</u>
~1.4430		Mo 2.6	32
		Cu <0.3	<u>Charpy V</u>
			Test Temps, °C Impact Values, J
			+20 175
			-60 150
			-196 75

